

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023697**Date Inspected:** 14-May-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai,China**CWI Name:** Liu Hua Jie/Lv Li Qing**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Nagalingam Pandaram Pillai was present during the times noted above for observations relative to the work being performed.

Magnetic Particle Testing:-

OBG Trial Assembly

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated an MT report for this date. The member is identified as OBG Segment 13AE Bottom Panel and Side Panel Stiffeners (Hold back areas). The weld designation reviewed is as follows:

SEG3007R-136,137,140,141,144,145,148,149,162,165,166

SP3060-001-025,02,027,028,029,030,031,032,033,034

SP3059-001-001,002,003,004,005,006,007,008,009,010,011,012,013,014.

In process Inspection:-

OBG Trial Assembly

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

This QA inspector observed the following work in progress:

SMAW welding of weld joint No: SEG3007R-163 located on OBG Segment 13AE Bottom Panel stiffener.

Welder is identified as #043661. ZPMC QC is identified as Mr. Zhong Yong Hong .Welding was performed with the weld repair report BWR-20954. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-3G(3F)-FCM-Repair-1.

This QA inspector observed the following work in progress:

SMAW welding of Bottom Panel temporary attachment removal areas located on OBG Segment 13AE. Welder is identified as #067572. ZPMC CWI is identified as Mr. Liu Hua Jie. Welding was performed with the Critical weld repair report CWR-2969. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G(4F)-FCM-Repair-1. Please see the attached picture.

This QA Inspector observed the following work in progress:

SMAW in the 2G position for the OBG Segment 14E Deck Panel to Edge panel. The weld joint was designated as: SEG3019*-017. The welder is identified as #037723. ZPMC QC is identified as Mr. Zhu Yuan Yuan. The welding variables recorded by QC appear to comply with WPS-B-T-2212-TC-U4B-FCM-1.

This QA Inspector observed the following work in progress:

SMAW in the 3G position for the OBG Segment 14E Deck Panel to Floor Beam. The weld joint was designated as: SEG3019D-1-142. The welder is identified as #051356. ZPMC QC is identified as Mr. Zhu Yuan Yuan. The welding variables recorded by QC appear to comply with WPS-B-T-2213-TC-U4B-FCM-1.

This QA Inspector observed the following work in progress:

SMAW in the 4G position for the OBG Segment 13CE Edge Panel Stiffener. The weld joint was designated as: CA3014-123. The welder is identified as #066258. ZPMC CWI is identified as Mr. Lv Li Qing. The welding variables recorded by QC appear to comply with WPS-B-P-2214-B-U2-FCM-1. Please see the attached picture.

This QA Inspector observed the following work in progress:

SMAW in the 1G position for the OBG Segment 13CE Edge Panel Stiffener. The weld joint was designated as: CA3014-147. The welder is identified as #066258. ZPMC CWI is identified as Mr. Lv Li Qing. The welding variables recorded by QC appear to comply with WPS-B-P-2211-B-U2-FCM-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

The ZPMC personnel performing SMAW according to the Critical weld repair report B-CWR 2969 on OBG 13AE&13BE Bottom Panel Temporary attachment Removal Areas.



OBG Segment 13CE

The ZPMC personnel performing SMAW for weld joint : CA3014-123



Edge Panel Stiffener

Summary of Conversations:

No Relevant Conversation.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By: Pillai,Pandaram

Quality Assurance Inspector

Reviewed By: Patel,Hiranch

QA Reviewer